	•			
Work Order ID 93253- November-15-12 10:36:27 AM	*93	253*	Page 1	
Item ID: D4093-3 Revision ID:	Accept	*N90004010	nn* Setup Start *NS1*	v
Item Name: Bracket			Stop *NS2*	•
Start Date: 11/15/12 Start Qty: 10.00	*10*	Cust Item ID:		
Required Date: 11/30/12 Req'd Qty: 10.00	*10*	Customer:		, e , ·
Reference:				
Approvals: Process Plan: MUS I	Date: 17-11-15 Tooling:	Date.	Run Start *NR1*	
	Date: SPC (Y/N);	Date:	- *NR2*	.;·
Sequence ID/ Operation Work Center ID Description	Set Up/ Run Hours	Tool ID Tool # Pla	n Accept Reject Reject Insp. de Qty Qty Number Stamp	
Draw Nbr Revision Nbr		-		•
- D4093 D			The state of the s	-
110	0.00			12-6
110 Waterjet Memo	0.00	, ,	109 AND IND	00- ZE
Waterjet Memo FLOW CNC Waterjet CUT AS DWG	0.00			9* A
6061 750×600 DWG REV.	\mathcal{O}		PTO -	>
****DEBURR*	***		,	
DEBORK			Ph -> B	12-12-6
120 QC2-Inspect parts off machi	ine FAI/FAIB 0.00	•	TO IA vect proc.	
120	**		109 0 42 Jm.12	ij. 20
QC Memo	0.00			
Quality Control	The second secon		N	
			Mossie	page
Company of the second of the s				~? <u>`</u>

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NCR:	(Yes) /	No

WORK ORDER NON-CONFORMANCE / UPDATE

1 1	- 1
DQA Date:	
DA Closed: (A Date: \(\)	

					,				QA Closed.	Of Date.	VL .	
Work Order	9	93253 DISPOSITION			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No	D4	093	5-3		Rework Scrap	/	Skid-tube Crosstube Water Jet Engineering Machining Small Fab Prod. Eng. Coor. Quality					
NCR No	o. <u>13</u>	,219	86		Use-as-is Work Order Update	the	rmoforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other	
Root			!	Descri	otion of work order update	Initial	Ad	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng Desc	cription	Date	Verification	QC Inspector	
Doc/Data L Equip/Tooling Operator	12-11-21	100	Д×	gauge Cut	out of center	CE CE	Scrap no re-	+ destroy.	13-11-51 2W		((() () () () () () () () ()	
Material Setup			,	inco	out. Program	05204	2	extra.		16	Q>2042	
Other Process		4		with	infort inside and not	13/01/0	b	Paramont page		13/01/03	13/0/05	
Supplier Training	-		†	(CO+00+	and not		au 2	regular &				
Unapproved	_			in a	Item part.		QH 10	J. K.				
X			•		F.	AULT CA	TEGORY /	13/		•		
Landing	g Gear				General		1,2					
	Bending				Bend	Grai	1		Ovalizeø		Pressure/Forced	
	Centre No	t Concer	ntric to	o/s	BOM/Route	Hard	ware	n Andri	Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspe	ction Incomplete	Ø, ₽ [Part Incorre	ct	Weld	
	Crushed/0	Crimped.		L	Burrs	Instr	ictions Incomplete	/Jonclear	Part Lost/Mi	issing	Wrong Stock Pulled	
	Cuffs	••			Contamination		ntenance		Part Moved			
_	Heat Trea	t	Countersink		Misla	beled		Positioned V				
	Inspection	•	Tube		Cut Too Short		ead		Power Loss/	Surge	Other	
	Ripples in		Drill Holes		Offse	-		Wate	yet Fort	in part,		
<u> </u>	Torque W		xtrüsio	n ₃ ·	Drawing		of Calibration		<u>nu+</u>	<u>- in wo</u>	iste in center	
1	Turning Se	-	<i>ే.</i> .		Finish	\vdash	of Sequence					
	Wave/Twi	ist in Tub	e	. * ;	Folio	1 Outs	de Dimensions					

November-15-1	2 10:36:27 A	IM		۸.٦	/:::-	~~~					
Item ID: Revision ID: Item Name:	D4093-3 Bracket			Accept	*N90	0040)1) () * s	Setup Star Stop	17	S1* S2*
Start Date: Required Date Reference:	11/15/12 : 11/30/12	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust It			_	Stan		• • • •
Approvals:		an:	Date:	Tooling: SPC (Y/N):		Date:		ŀ	Run Star Stoj		R1* R2*
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool	ID Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Mill Conv Conventional Milli	ng Machine	Memo DRILL AND	OC'SINK AS PER DWG	0.00	*.) 12-12-1	ર્ષ		9	. 1		Pto->.
132 *132* QC Quality Control		QC2- Inspect parts off m	achine FAI/FAIB	0.00 0.00	12-12-1	9	-	9	- 	<i>i</i>	PTO
135 *135* QC Quality Control		QC8- Inspect parts - seco	and check	0.00	12/19	3\03		9	4		(SAS 80 8.0

NCR:	Yes //	No

WORK ORDER NON-CONFORMANCE / UPDATE

	377	-	
DQA: Jul L Date: 13/1/14	+	•	
) 		•	_
1			

								QA Closed.	O\ Date.	()
Work Order	q.	93253			DISPOSITION		AGAINS	T DEPARTMENT	/PROCESS	
Part No	o	<u>D4093-3</u> Rework Scrap Use-as-is			Ther	Skid-tube Crosstube Water Jet Engineering Machining Small Fab Prod. Eng. Coor. Quality Thermoforming Finishing Rec/Store/Packaging Other Large Fab Composite Supplier				
Root	1	I		Descri	otion of work order update	Initial	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	ł.	Date	 Verification	QC Inspector
Doc/Data Equip/Tooling Operator	2			400 p	Note mre all		Scrap.	Se so	0AS 15	**
Material Setup Other Process	19/1/21	10:0 *	(£ 9)	AND ANC R.C. due Hirde	AND AR not Round. "(due to Propor on w/3 For tide material + Jet uffert		HOLES SHOULD BE FINISHED BY HAND	,	, , , ,	0 AS). 16, 12/w/2/
Supplier Training Unapproved			·	Offset a. Cemireson	ffeet unable to advice correct		DRILL BIT WWW REPORC M 121 380			
	<u> </u>				F.A.	ULT CATI	GORY			
Landing	 1			<u></u>	General			Ovalized		_
	Bending Centre No	ot Concer	ntric to (o/s	Bend BOM/Route	_	Grain Hardware		tolerance	Pressure/Forced Temperature/Cure
<u> </u>	Cracks	*.		<u></u>	Broken/Damaged	Inspec	tion Incomplete	Part Incorre	ct	Weld
	 1	ed/Crimped. Burrs		Instruc	tions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs	Contamination			enance	Part Moved				
	⊣	Heat Treat Countersink		Mislab		Positioned \		, .		
_	Inspection Strip in Tube Cut Too Short		Misrea	d	Power Loss/	/Surge	Other			
-	Ripples in Bend Drill Holes		Offset							
	Torque W		xtrusio	-	Drawing	⊢	Calibration			
	Turning S	•			Finish		Sequence			
	Wave/Tw	Wave/Twist in Tube Folio		Outsid	e Dimensions					

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NCR:	Yes	1	Nο
INCh.	162	,	140

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	 Date:	t	
- . Classal.	Doto	٠,	

											QA Closed:	Date:	
Work Order:	9=	93253 DISPOSITION				AGAINST DEPARTMENT/PROCESS							
	D40				Rework Scrap Use-as-is Work Order Update		1 1	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		⊣		Engineering Quality Other	
Root				1	•'	order update	Initi	1	Actio	n	Sign &		
Cause	Date	Step	Qty		or Non-confor		Chief		Descrip		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material	12-12-18	(80	ŧ	drilliv ba	ing 0.050 the early of part.	Holes bit inside Use better	13.01	1.07	- Surep - USE mi	destray. Ming machine Miles.	Jm 12-12-18	More.s	0AS 16
Setup	-	11		V	se to a	role pont.	_		Oty XI			100	100
Other Process Supplier Training Unapproved	12-12-28		Į.		location youd to	of 1500 lecance	13-on	oz	ACCEPTABLE DEVIATION. Oby 1		D- 12-12-28	Blowles	QS Z042 13 loil 03
						F/	AULT C	ATEC	ORY		· · · · · /		
Landing	Gear Bending Centre No	ot Concer	ntric to	o/s	Gen Bend BOM/Route	neral	Gra	ain rdwai	re		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	Cracks				Broken/Dam	aged	-		on Incomplete		Part Incorre	-	Weld
	Crushed/0	Crimped.			Burrs		Ins	tructi	ons Incomplete/Un	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination			ainte	nance		Part Moved		
l	Heat Trea	t		Countersink		Mis	slabel	led		Positioned V	Vrong	- /	
	Inspection Strip in Tube Cut Too Short		ЩMi:	śread			Power Loss/	Surge 🟲	Other				
	Ripples in Bend Drill Holes		H-1	fset									
-	Torque W		xtrusio	n	Drawing		⊢⊣		alibration		Broken	bit insi	de port
<u> </u>	Turning S	•			Finish		\vdash		equence				·
	Wave/Twist in Tube Folio				Outside Dimensions								

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Work Ord	ler ID 93253
November-15-	12 10:36:27 AM
Item ID:	D4093-3
Revision ID:	

93253

Page 4

November-15-1	2 10:30:27 A	I <i>M</i>											<u>-:</u>
Item ID: Revision ID:	D4093-3			Accept	*N900	040	100)* s	Setup	Start	*N.S		
Item Name:	Bracket									Stop	*N.S	32 *	
Start Date:	11/15/12	Start Qty: 10.00	*10*		Cust Item I	D:							
Required Date	e: 11/30/12	Req'd Qty: 10.00	*10*		Customer:								
Reference:													
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:		F	Run	Start	*NF	21*	
	QC:		Date:	_ SPC (Y/N):	Da	ate:				Stop	*NF	? 2*	
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
180		QC21- Final Inspection -	Work Order Release	0.00						1	1 6	2/2	
120	<i>-</i> * .	Memo		0.00						13/1	110 9		-
Quality Control		Mento								•	M	F	

13-01-07

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	Part No.					Rework Scrap			Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Use-as-is Work Order Update]	1	noforming Large Fab	Finishing Composite	Rec/Sto	Supplier	Other
Root					Descri	ption of work order update		Initial	Ac ⁻	tion	Sign &	·	
Cause		Date	Step	Qty	C	or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1							·				
Equip/Tooling													
Operator									·				
Material						-							
Setup		1											
Other													
Process													
Supplier													
Training													
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng (Gear				General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concen	tric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre		Weld
		Crushed/	Crimped.			Burrs		4	ions Incomplete/	Unclear	Part Lost/M	. —	Wrong Stock Pulled
	П	Cuffs	•			Contamination		Mainte	•		Part Moved	~ <u>L</u>	_
		Heat Trea	t			Countersink		Mislabe			Positioned V	Vrong	
		Inspection	Strip in	Tube		Cut Too Short		Misread			Power Loss/		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

November-15-12 10:36:27 AM

Work Order ID:

93253

Parent Item:

D4093-3

Parent Item Name:

Bracket

Start Date: 11/15/12

Required Date: 11/30/12

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD

598 11-06-05 JLM VERIFIED BY:DD

IPP REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

IPP REV:C 12.10.31 AS PER

	DWG REV.C DD	VERF:JLM											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.000 6061T6 BAR .750 X 6.00		Purchased	No				f	28.0000	Section 1885	6.105263 6.25	6.5	and the same of th	Jm 12-

121386

		DQA:	Date:	, .
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / LIPDATE			•

NCR:	yes	/ No				WORK ORDER NON-	JUi	NFORI	VIANCE / UP	DATE	QA Closed:	Date	· 2:
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.	<i>y</i>				Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Rooth					Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	2 104									·			
						F	AUL	T CATE	GORY				
Landi	ng (Gear			,	General	_				•	_	
		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t n Strip in Bend 'aves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/ nance led I	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning So	equence		J	Finish	1 '	Jour or S	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	9353
Description: BRACKER	Part Number:	D4093-3
Inspection Dwg: 04x73-2 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
1.05	4 336	1.037			V 002	
3,98 -	12 03x	3.835	<u> </u>		V	
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.55	2 -30	,496	U		V	
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Measured by:	B
Date:	12-12-6

Audited by:	D
Date:	12-12-19

Preliminary Approval:	
Date:	

DART AEROSPACE LTD	Work Order:	93253
Description: Bracket	Part Number:	4093-3
Inspection Dwg: 4093 Rev: D		Page 1 of 1

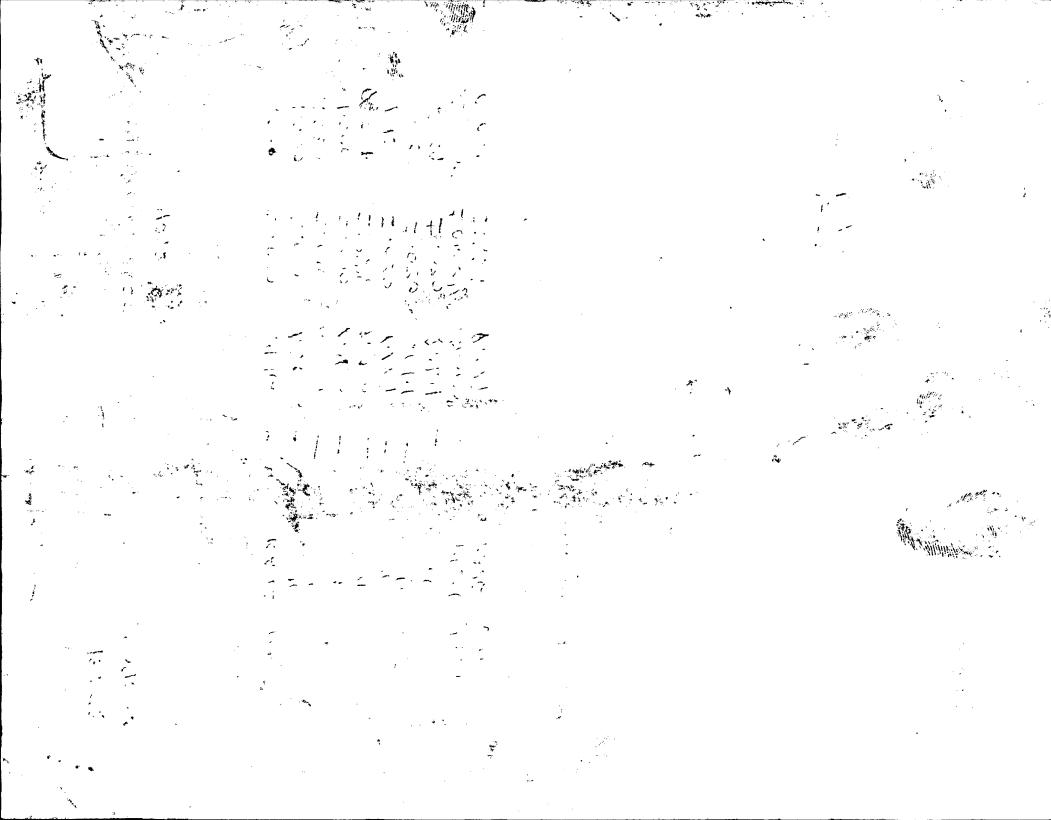
FIRST ARTICLE INSPECTION CHECKLIST

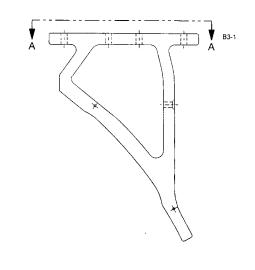
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1,500	4,010	1,508			11	
2.530	4.00	2.537			/(
1.500	±.010	1.498			F	
9.200	41	1.149			/1	
1,13	± 0000	1.149			11	
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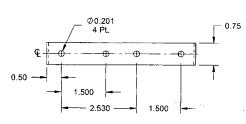
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				4		

•	Dr. C.	<u></u>
Measured by:	Audited by: De 08	Preliminary Approval:
Date: 12-12-20	Date: 12/13/03	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	







SECTION VIEW A-A D6-1

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4117/4128/4115/4116)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.55 lbs

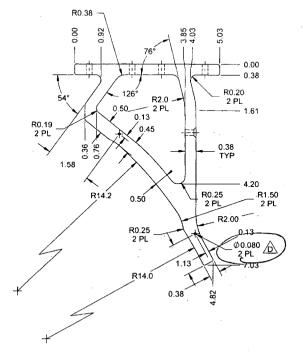
Α

D4093-1 BRACKET

D	ADD Ø0.080 HOLES (ZN B5-2, B5-4)	RF	12.09.18
С	REDRAWN D4093-1/-3 (ZN B4-1, B4-2); ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
В	REDRAWN D4093-1/-3 (ZN B4-1, B4-2)	RF	11.01.31
Α	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE

1 14 C 14	330L		[RF	10.09.10
REV.		DESCRIPTION	BY	DATE
DESIGN:	RF	DART AEROSE	ACE USA	INC.
DRAWN	RF		IT, WA	,
CHECKED	A	DRAWING NO.		REV. D
MFG. APPR.	A.F.	D4093		SHEET 1 OF 5
APPROVED	Al I	TITLE		SCALE
DE APPR.	- CH	BRACKET		NTS
DATE 12.	09.18	COPYRIGHT © 2010 BY I THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AN NOT TO BE USED FOR ANY PURPOSE OR COPED	ID IS SUPPLIED ON THE EXPRESS	CONDITION THAT IT IS

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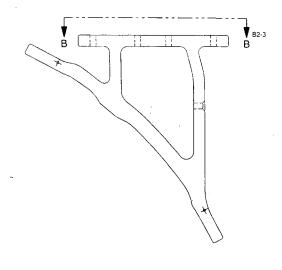


2.39 Ø0.201 -C'SINK Ø0.370 x 100° CHAMFER

D4093-1 BRACKET

DESIGN	RF	DART AEROSPA	CE USA, INC.
DRAWN	RF	KENT.	WA
CHECKED	\$	DRAWING NO.	REV. D
MFG. APPR.	AV.	D4093	SHEET 2 OF 5
APPROVED	41	TITLE	SCALE
DE APPR.	4	BRACKET	NTS
DATE 12.0	9.18	COPYRIGHT © 2010 BY DA THIS DOCUMENT IS PRIVATE AND CONTRENTIAL AND IS HOT TO BE USED FOR ANY PURPOSE OR COPIED OR C	S SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

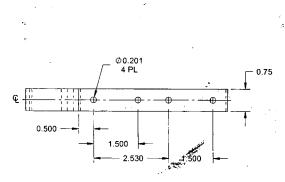
8



D4093-3 BRACKET

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061 T6B/M6061 T6S
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.64 lbs"

8



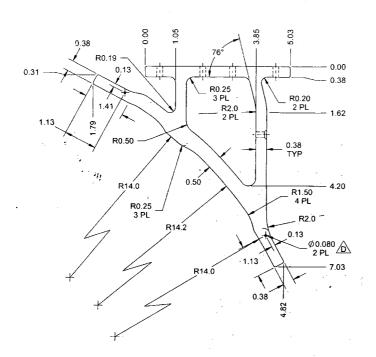
SECTION VIEW B-B 85-3



DESIGN	RF.	DART ÄEROSPA	CE USA, INC.
DRAWN	RF	KENT,	
CHECKED	85	DRAWING NO.	REV. D
MFG. APPR.	X.	D4093	SHEET 3 OF 5
APPROVED	4	TITLE .	SCALE
DE APPR.	-	BRACKET ,	NTS
DATE 12.0	9.18	COPYRIGHT © 2010 BY DAI THIS COCUMENT IS PROVATE AND CONFIDENTIAL AND IS NOT TO BE USED FOR ANY PURPOSE OR COPYED OR C	SUPPLIED ON THE EXPRESS CONDITION THAT IT IS

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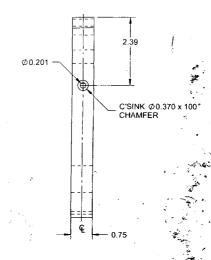
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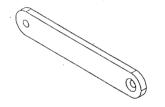


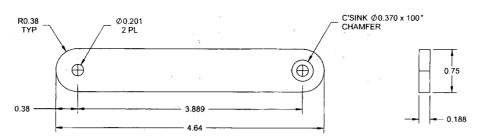
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	DESIGN	· RF _i ···	DART AEROSPACE USA/INC.
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	MFG. APPR.	A.	D4093 SHEET 4 OF 5
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D4093-5 BRACKET

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 QR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.06 ibs



DESIGN	RF	DART AEROSPA	CE USA, INC.
DRAWN	RF	KENT,	WA
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MFG. APPR.	A.	D4093	SHEET 5 OF 5
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